

Date: Thursday, 1/17/2008 3:31:56 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STIFFENER		
Job Number	: 36851			Part Number	: D2353		
Estimate Number	: 10481			Drawing Number	: D2353 REV.C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 1/17/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 2/10/2008		
Previous Run	: 31920			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev: A Removed from 9 Digit 05-11-10 EC						
	Est: B 06.11.15 waterjet EC						
	est: c 06.12.07 ecn 836 ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		 <i>2.</i>
Comment: Qty.: 0.1536 sf(s)/Unit Total : 1.5362 sf(s) Material: 2024-T3 .050 sheet Aluminum (QQ-A-250/5) Batch: <u>105646</u> <i>LB 8-1-21</i>		
2.0	WATER JET	FLOW WATER JET
		 <i>12</i>
Comment: FLOW WATER JET 1-Cut as per Dwg D2353 Dwg Rev: <u>C</u> <i>LB 8-1-21</i> Prog Rev: <u>C</u> <i>LB 8-1-21</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>LB 8-1-21</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

4.0	QC8	SECOND CHECK
		 <i>LB 8-1-21</i>
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

SB 08/01/29

(12)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Co 08/01/29 (12)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 8-1-30 (12)

8.0 POWDER COATING POWDER COATING



M 100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

AS 08-01-31 (12)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 100700 08/31/31

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*****Identify BAG with fine point permanent marker and Stock*****

Location: ST 185

AS 08/02/01

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/04 (12)

Job Completion



min 2008/2/04

W

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36851
Description: Stiffener	Part Number:	D2353
Inspection Dwg: D2353	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

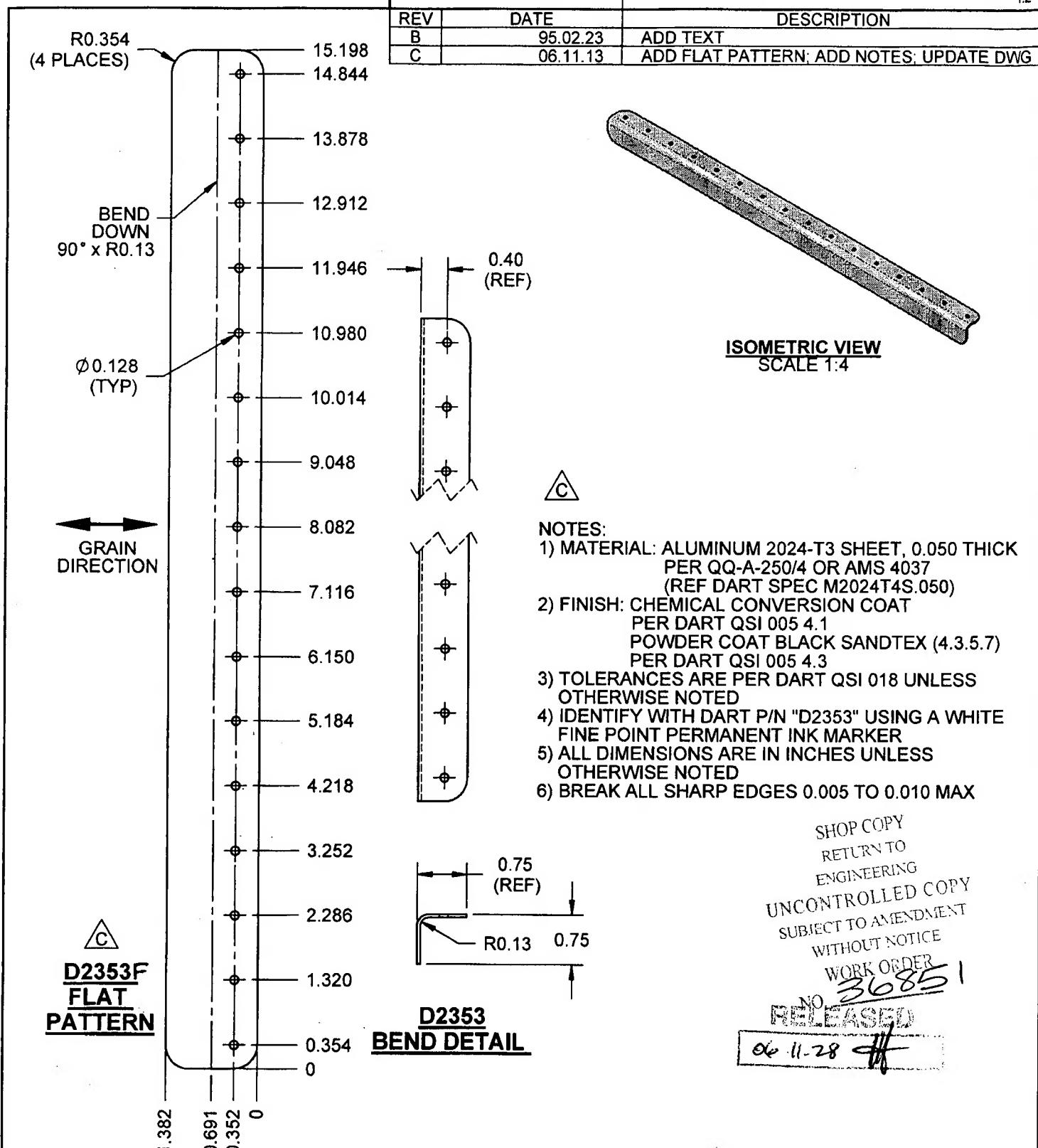
Measured by: <u>WB</u>	Audited by: <u>cf</u>	Prototype Approval:	N/A
Date: <u>8-1-21</u>	Date: <u>08/01/22</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED CE	APPROVED H	DRAWING NO. D2353	REV. C	SHEET 1 OF 1
DATE 06.11.13		TITLE STIFFENER	SCALE 1:2	

REV	DATE	DESCRIPTION
B	95.02.23	ADD TEXT
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG



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